

A SAP

Dart Aerospace Ltd.

Date: Wednesday, 21/05/2008 2:04:51 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE ASSEMBLY
Job Number	: 39375		
Estimate Number	: 12709		
P.O. Number	:	Part Number	: D3572041
This Issue	: 21/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3572 REV.C
First Issue	: / /	Project Number	: N/A
Previous Run	: 38300	Drawing Revision	:
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 28/05/2008
Checked & Approved By	: <u>mf</u>	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 07-02-07 JLM est rev B revB dwg EC Est Rev:C Removed D3572-7 Cap 07-06-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35723	Guide
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

GUIDE

Batch: 339313

28.05.27 4

2.0	D35725	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

Batch: 332415

28.05.27 4

3.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W
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Comment: Qty.: 2.3405 f(s)/Unit Total : 9.3618 f(s)

6061-T6 Round Tube 1.00"x 0.188 wall

Batch: M104490

28.05.27 4

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut Tube D3572-1 as per Dwg D3572

2-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572

A/R AL ROD

Batch: M106834

28.05.27 4

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 39375

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 247

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

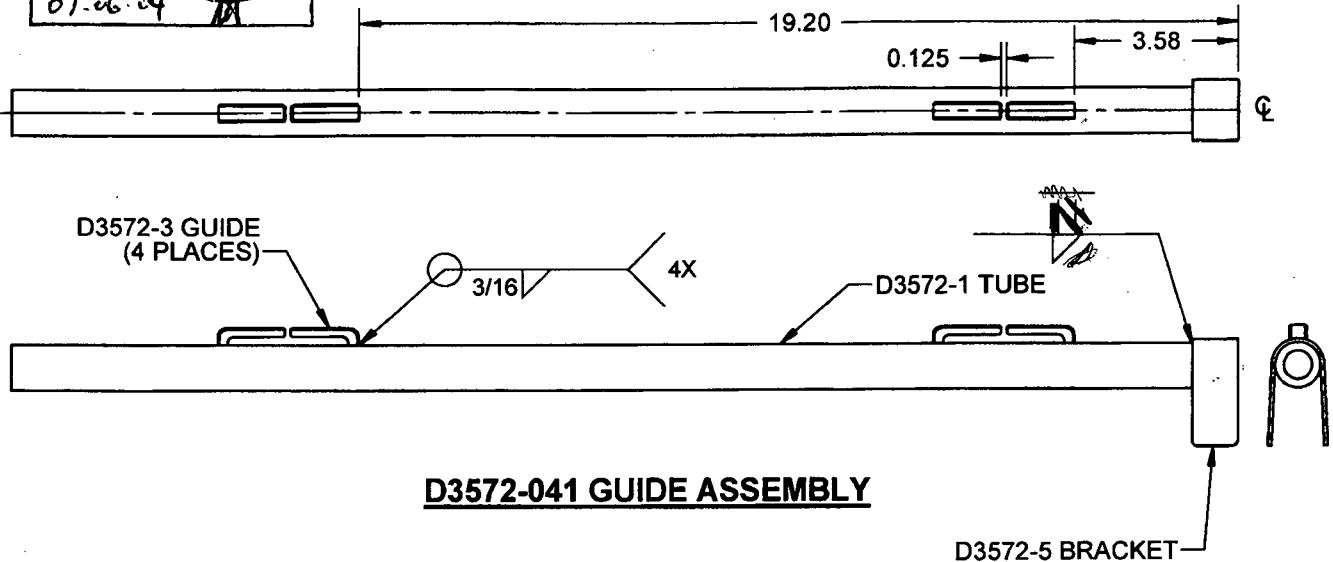


30 min
28/05/2006
S.284 08.11
#1 315.0 F
#2 D3572041 F
#3 D3572041 F
#4 D39375 F

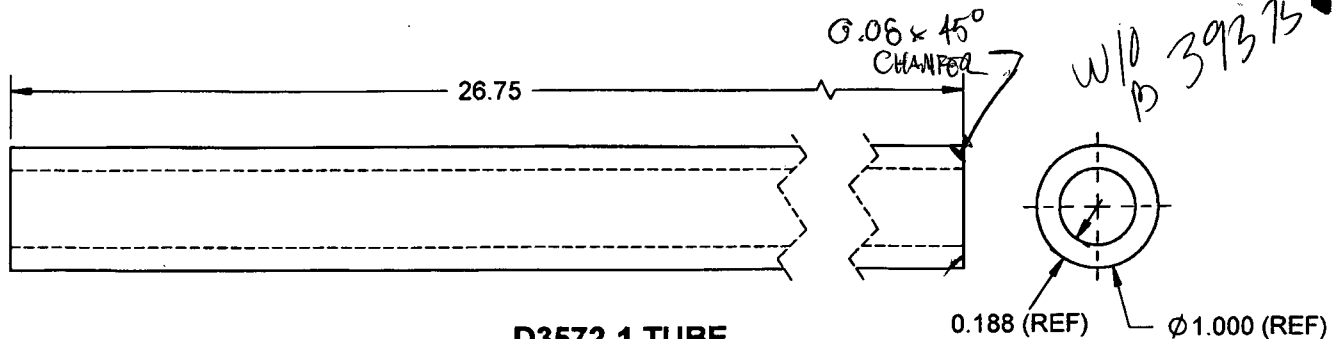
u 08.05.28

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED07.06.01 *H***D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 NOTES:**

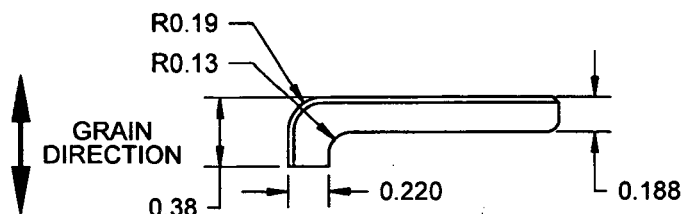
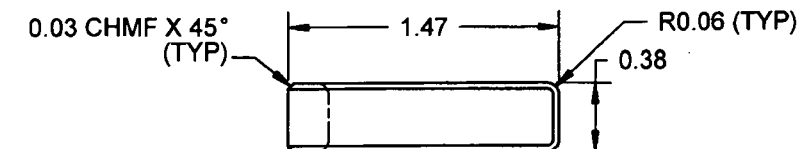
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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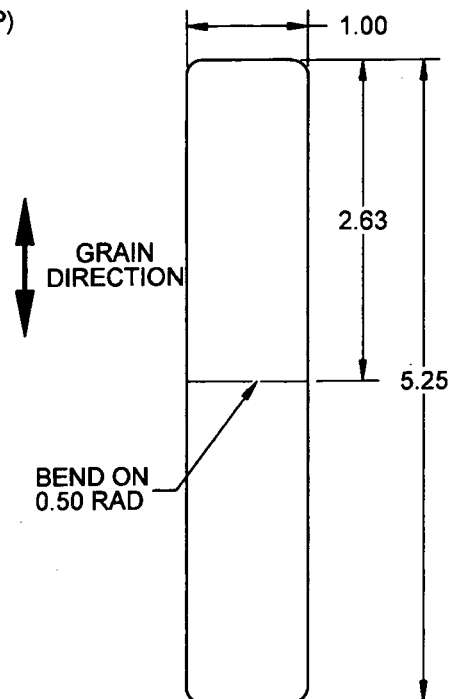
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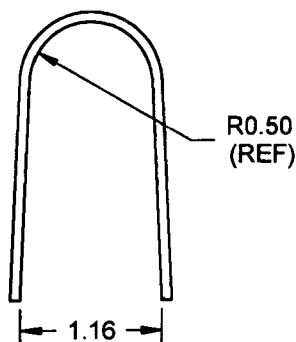
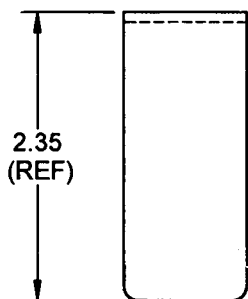
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)

RELEASED
07.06.01 H

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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